

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021799**Date Inspected:** 07-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14 East

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Zhong Yong Gang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SA-3013-001

Weld No: 003

Welder: 051356

WPS-B-T-2232-ESAB

PCMK: SEG-3007G

Weld No: 014

Welder: 055491

WPS-B-T-2233-ESAB

PCMK: SEG-3007L

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Weld No: 040  
Welder: 050242  
WPS-B-T-2232-ESAB

PCMK: SEG-3007C  
Weld No: 255  
Welder: 055564  
WPS-B-T-2232-ESAB

This QA Inspector observed the following work in progress for Bay 14.  
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.  
ZPMC QC is identified as Zhong Yong Gang.  
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).  
Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3019AW  
Weld No: 096  
Welder: 054013  
WPS-B-P-2212-TC-U4b-FCM-1

PCMK: SEG-3019AW  
Weld No: 100  
Welder: 215553  
WPS-B-P-2212-TC-U4b-FCM-1

PCMK: SEG-3019Q-1  
Weld No: 117, 119, and 121  
Welder: 050969  
WPS-B-P-4213-TC-U4b

PCMK: DP-3079-001  
Weld No: 014 and 015  
Welder: 037748  
WPS-B-P-2114-FCM-1

PCMK: SEG-3019L  
Weld No: 047~049  
Welder: 044779  
WPS-B-P-2214-TC-U4b-FCM-1

Bay 16  
This QA Inspector observed the following work in progress for Bay 16.  
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.  
ZPMC QC is identified as Ma Qian Li.

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Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).  
Listed below are the locations that were identified by this QA inspector.

PCMK: E5-SB22A-001  
Weld No: 001~012, 017 and 018  
Welder: 201905  
WPS-B-T-2113

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Ma Qian Li.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).  
Listed below are the locations that were identified by this QA inspector.

PCMK: W2-SB18A-001  
Weld No: 013~016 and 020~025  
Welder: 201074  
WPS-B-T-2132-ESAB

PCMK: E5-SB25B-001  
Weld No: 050  
Welder: 062092  
WPS-B-T-2231-ESAB

PCMK: W2-SB19-001  
Weld No: 094~098 and 112~114  
Welder: 201888  
WPS-B-T-2132-ESAB

PCMK: W2-SB19-001  
Weld No: 001~012, 017 and 018  
Welder: 201888  
WPS-B-T-2133-ESAB

PCMK: W2-SB25-002  
Weld No: 96 and 100~105  
Welder: 222390  
WPS-B-T-2133-ESAB

PCMK: W2-SB25-002  
Weld No: 126~131  
Welder: 222390  
WPS-B-T-2132-ESAB

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Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Heat Straightening process.

ZPMC QC is identified as Ma Qian Li.

Welding variables recorded by QC appeared to comply with the approved Heat Straightening Procedure Specification (HSR). Listed below are the locations that were identified by this QA inspector.

PCMK: SB-106W

HSR-1(B)-9955

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



## Summary of Conversations:

No relevant conversations were reported on this date.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Rice,Brett	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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